User:

Monday, 22/09/2008 10:36:22 AM

Julie Lecocq

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 42153

S.O. No. :

**Estimate Number** 

: 10512

P.O. Number This Issue

: 22/09/2008

: NC

Prsht Rev. First Issue

: //

: MACHINED PARTS Type

**Previous Run** 

: 41971

Written By

Checked & Approved By Comment

: Est: Est:

02.04.15 B 05.12.12

added deburr EC

**Drawing Name** 

Part Number

: D26511 D2651 REV. B

: PLUG

**Drawing Number Project Number Drawing Revision** 

: N/A : B

Material

Due Date

: 29/09/2008

Qty:

200 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6061-T6 Round Bar .500"

1.0

2.0

M6061T6R0500



Comment: Qty.:

0.0421 f(s)/Unit Total:

8.4210 f(s)

NG

Material: 6061-T6 (QQ-A-225/8) 0.500" Dia

(M6061T6R0500)

Batch: M 107676 HARDINGE

HARDINGE CNC LATHE SMALL





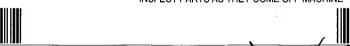


Comment: HAAS CNC VERTICAL MACHINING #1

1- Turn as per Folio FA219 and Dwg D2651

2- Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHIN



Comment: INSPEC ARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1



5.0

SMALL FAB 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr ias per dwg D2651



Duit Aci	OSPace	, Ltu							
W/O:		14	WO	RK ORDER CHANGE	ES				-
DATE STEE		PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			·	V•	34				
		PAR #:	Fault Cate	; gory: <sup>‡</sup>	NCR: Yes No DQA: Date:				
		esolution:	Disposition	n:	QA: N/C	Closed:		Date:	
NCR:		:	WORK ORDE	R NON-CONFORMA	NCE (NC	R)		,	
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sigr	1& Secti	cation on C	Approval Chief Eng	Approval QC Inspector
						, a			

Date: Monday, 22/09/2008 10:36:22 AM User: Julie Lecocq **Process Sheet Drawing Name: PLUG** Customer: CU-DAR001 Dart Helicopters Services Job Number: 42153 Part Number: D26511 Job Number: Seq. #: Machine Or Operation: Description: HAND FINISHING1 6.0 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 7.0 POWDER COATING **Comment: POWDER COATING** Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 (Only larger section necessary) START TIME: **OVEN TEMPERATURE:** FINISH TIME: INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 Comment: INSPECT POWDER COAT 9.0 PACKAGING 1 PACKAGING RESOURCE Comment: PACKAGING RESOURCE #1 Identify and Stock Location: QC21 10.0 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE MF 08-09-30 Job Completion

W/O:		4	WC	ORK ORDER CHANGE	S					
DATE STEP		PROCEDÚŘE CHANGE By Date Qty						Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		•								
				N.						
										0
Part No:		PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	A:	_ Date: _	
	Res	solution:	Dispositio	QA:	N/C CIG					
NCR:		,	WORK ORD	ER NON-CONFORMAI	NCE	(NCR	)			
DATE	STEP	Description of NC	Corrective Action Section B			Ciam 0		cation	Approval	Approval
DAIL	J.L.	Section A	Chief Eng	Initial Action Description Chief Eng Chief Eng			Sign & Section C		Chief Eng	QC Inspector
					,					
				.,			4			

DART AEROSPACE LTD	Work Order: 43155
Description: Plug	Part Number: D2651-1
Inspection Dwg: D2651 Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

		First Arti	_	_	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
0.060	+/-0.005	.061			,		·
0.375	+/-0.010	.374	/				
0.050 x 20°	+/-0.010	.050x2d		4.0			
Ø0.305	+0.000/-0.002	0.304					
Ø0.438	+/-0.005	0.4375	//				
0.060	+/-0.005	.057					
0.090	+0.000/-0.002	.088					
0.045	+0.000/-0.002	.043	/				
	,			ν.			•
. :				(6)			
-				2			
4		Audited by	77 11				NI/A
Measured by: S	8/08/22	Audited by: Date:	of a	9.2	Prototype App	Date:	N/A
Rev Date A 03.12.22	Change New Issue			-	R	evised by	Approve

W/O:		WORK ORDER CHANGES								
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	):	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date: _				

NCR:		,	WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NO		Verification		Approva						
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspecto				
						•						
				ė.								

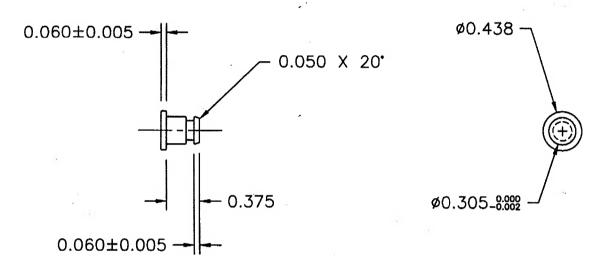




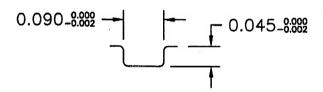
		and the second s	
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
#	1 9K	D2651 SHEET	1 OF 1
DATE		TITLE	SCALE
 03.12.19		PLUG	1:1
 Α	97.03.25	NEW ISSUE	
В	03.12.19	ADD POWDER COAT, MS28775-008	

# RELEASED

#### D2651-1 PLUG:



## **GROOVE DETAIL (SCALE 5:1)**



#### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

## D2651-3 O-RING

1) MATERIAL: BUNA N, 70 DUROMETER 3/16 ID, 5/16 OD, 1/16 WIDTH (PARKER 2-008, MS28775-008 OR EQUIVALENT)

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W/O:			W	ORK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CH	ANGE	By Date Qty				Approval Chief Eng / Prod Mgr	Eng / Approvat	
		· .									
		*	38(								
		*								Ĭ.	
		PAR #:	Fault Cat	egory:	NCR: Yes No DQA: Date:						
		esolution:	olution: Disposition:				QA: N/C Closed: Date:				
NCR:			WORK ORI	DER NON-CONFORM	ANCE	(NCR	)				
DATE	STEP	Description of NC	Initial	Corrective Action Sec Action Description	tion B	Verific	Verification Approva		Approval		
		Section A	Chief Eng	Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector	
				, , , , , , , , , , , , , , , , , , ,							